

Work Order ID 154990

Wednesday, January 04, 2017 2:22:32 PM

154990

Page 1

Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 1/17/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 1/24/2017 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

DAS

21

9-89

Date: JAN 04 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	E								

110

0.01

110

FLOW WATER JET

Waterjet

Memo

0.20

FLOW CNC Waterjet

1-Cut D3537-1 as per Dwg D3537

Dwg Rev: EProg Rev: E

2-Deburr if necessary

(42)

DC 17/01/05

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.07

Quality Control

(42)

DC 17/01/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 1/17/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 1/24/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.01 0.13							
						(42)	17.01.05		DAS 9 9-89
140 *140* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.33			DAS 30 9-89	(42)			JAN 06 2017
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.13				(42)	17.01.06		DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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160 *160* autoweld 1 Automated Welding 1	Weld per dwg & QSI004 4.5 Large Fab Memo ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: <u>M135462</u>	0.00 0.67				<u>42</u>	<u>17-1-30</u>		
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.07				<u>42</u>			DAS 38 9-00 JAN 31 2017
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.13				<u>42</u>			DAS 38 9-00 JAN 31 2017

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Work Order ID 154990

154990

Page 4

Wednesday, January 04, 2017 2:22:32 PM

Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 1/17/2017 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 1/24/2017 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : FP001	0.00 0.07			42	DAS 6 9-89		FEB 01 2017	
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.67							17/02/01 CME 17-2-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

Wednesday, January 04, 2017 2:22:36 PM

Page 1
f

Work Order ID: 154990

154990

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 1/17/2017

Required Date: 1/24/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM
15.10.16 added automated welding DD verf:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	131.3700	0.106	4.463158			

M304S16GA

304/316 Sheet .063

17/01/05

Location

Loc Qty

Loc Code

MAT010

131.37

m134604

7

m136036

34.97

m136327

89.4

4.9

DQA: _____ Date: _____

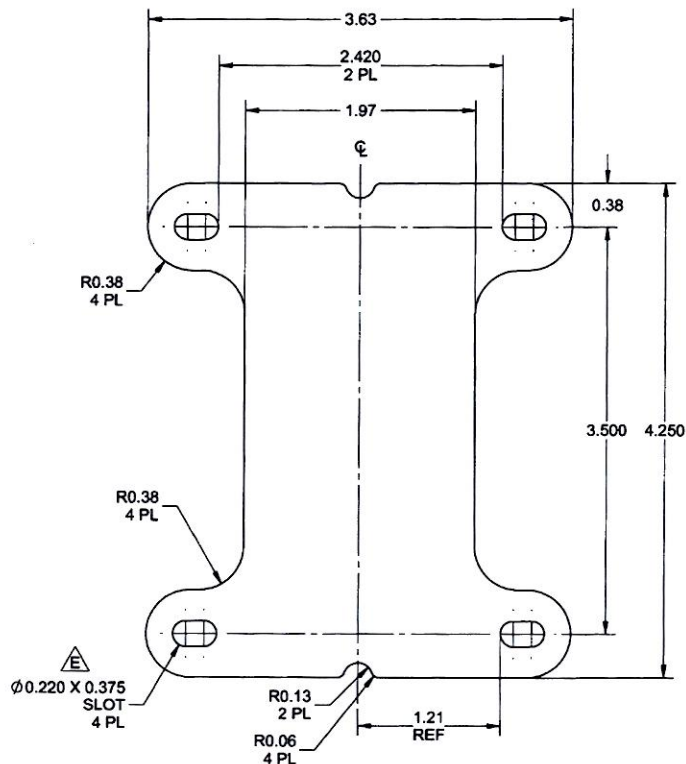


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

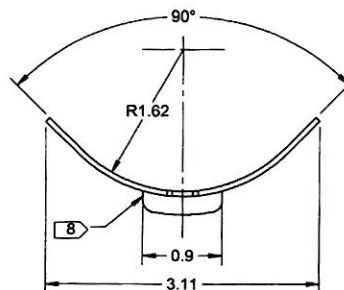
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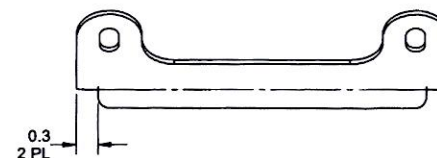
D3537-1F WEARPAD
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-6059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC: M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) BUILDUP HARD SURFACING 0.17 - 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 - 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)



D3537-1 WEARPAD
MAKE FROM D3537-1F



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 154990 MCS
17-01-04

RELEASED
2015-12-07
EUN 15-651

E	-5 DELETED PART IS OBSOLETE. RE-FORMAT. NOTE 8 RE-WRITTEN FOR ROBOTIC WELDING. SHEETS 1 & 2 SLOT DIMENSION UPDATED.	AJS	15.09.28
D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WEL. PATTERN	CB	07.04.13
B	ADD AMS5510 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	06.11.06
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3537	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	15.09.28	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED